

Order 12993



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D4434-041

Job Sheet 189578



Part No: D4434-041

Job Qty: 6 pcs

Part Name: Fwd Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/19

Job Tracking No:

Due Date: 2/12/19

Created By: Dara Macdonald

Type: SOLD

Description:

**Note:** DWG REV C SHEET 1 IPP revA 11.10.06 new issue EC verified by:DD IPP RevB 11.12.22 per PA5 EC  
verified by:JLM IPP RevC 12.01.24 per REV.A DD verified by:EC IPP REV:D 12.01.23 AS PER REV.B DD  
VERF:EC

Ship Via:

## Bill of Materials

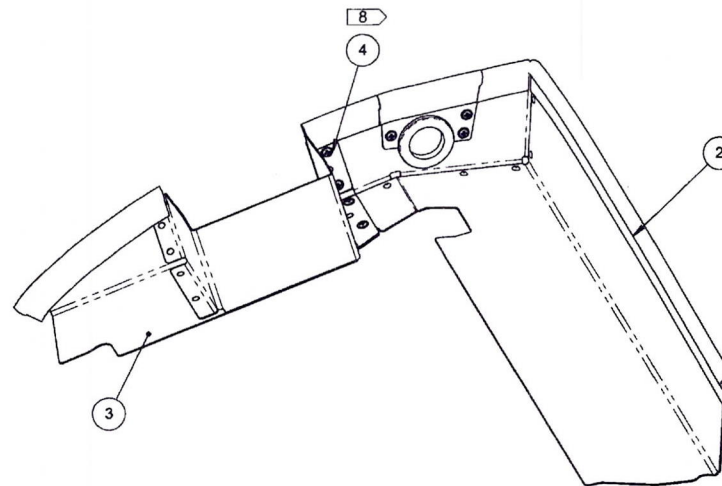
## Job Routing

| Op No | Operation                   | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                         |
|-------|-----------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------------------------|
|       |                             |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                                  |
| 100   | Small Fab - 1               | 6 pcs | 2/12/19    |          | 0.00      | 1.36    | Small Fab - 1         |           | DAS<br>58 FEB 22 2019<br>9-89    |
|       |                             |       |            |          |           |         | Small Fab - 2         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 3         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 4         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 5         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 6         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 7         |           |                                  |
| 110   | QC 5                        | 6 pcs | 2/12/19    |          | 0.00      | 0.00    | QC 5 - 10             |           | DAS<br>FEB 22 2019<br>68<br>9-89 |
|       |                             |       |            |          |           |         | QC 5 - 12             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 17             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 18             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 19             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 22             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 24             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 3              |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 38             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 42             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 43             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 49             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 51             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 58             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 68             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 9              |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 50             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 30             |           |                                  |
| 120   | Packaging 3-1 - Stock - B4B | 6 pcs | 2/12/19    |          | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           | FEB 22 2019                      |
|       |                             |       |            |          |           |         | Packaging 3 - 2 - B4B |           |                                  |
|       |                             |       |            |          |           |         | Packaging 3 - 3 - B4B |           |                                  |
|       |                             |       |            |          |           |         | Packaging 3 - 4 - B4B |           |                                  |

Plex 1/28/19 2:25 PM Dart.Macdonald.Dara

|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 5 - B4B  |                   |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------|--------------|-------------------|-----------|------------------------|-------------------|
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 6 - B4B  |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 7 - B4B  |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 8 - B4B  |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 9 - B4B  |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 10 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 11 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 12 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 13 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 14 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 15 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 16 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 17 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 18 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 19 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 20 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 21 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 22 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 23 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 24 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 25 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 26 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 27 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 28 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 29 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 30 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 31 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 32 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 33 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 34 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 35 - B4B |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | Packaging 3 - 36 - B4B |                   |
| 130                                                                                                                                                                                                                                | QC 21 - SA                    | 6 pcs        | 2/12/19           | 0.00 0.00 | QC 21 - SA - 21        |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           | QC 21 - SA - 70        |                   |
|                                                                                                                                                                                                                                    |                               |              |                   |           |                        | DAC<br>21<br>9-89 |
| Part Op <b>100</b> - Small Fab<br>Descriptions: <b>110</b> - QC5- Inspect part completeness to step on W/O<br><b>120</b> - Identify as per dwg & Stock Location: _____<br><b>130</b> - QC21- Final Inspection - Work Order Release |                               |              |                   |           |                        | FEB 22 2019       |
| <b>Job BOM</b>                                                                                                                                                                                                                     |                               |              |                   |           |                        |                   |
| Part / Item                                                                                                                                                                                                                        | Component Name                | Quantity     | Operation         | Container |                        |                   |
| AN525-832R7                                                                                                                                                                                                                        | Screw                         | 24 Ea (4 ea) | 100-Small Fab - 1 |           |                        |                   |
| D4434-043                                                                                                                                                                                                                          | Fwd Inboard Bracket Assembly  | 6 pcs (1 ea) | 100-Small Fab - 1 |           |                        |                   |
| D4434-045                                                                                                                                                                                                                          | Fwd Outboard Bracket Assembly | 6 pcs (1 ea) | 100-Small Fab - 1 |           |                        |                   |
| <b>Job Allocations</b>                                                                                                                                                                                                             |                               |              |                   |           |                        |                   |
| Operation                                                                                                                                                                                                                          | Component Part                | Required     | Inventory         | Allocated |                        |                   |
| 100-Small Fab - 1                                                                                                                                                                                                                  | AN525-832R7                   | 24           | 135               | 0         |                        |                   |
|                                                                                                                                                                                                                                    | D4434-043                     | 6            | 5                 | 0         |                        |                   |
|                                                                                                                                                                                                                                    | D4434-045                     | 6            | 0                 | 0         |                        |                   |
| <b>Part Specifications</b>                                                                                                                                                                                                         |                               |              |                   |           |                        |                   |
| Specifications could not be found.                                                                                                                                                                                                 |                               |              |                   |           |                        |                   |

| ITEM | QTY.<br>-041 | PART NUMBER | DESCRIPTION                   |
|------|--------------|-------------|-------------------------------|
| 1    | X            | D4434-041   | FWD BRACKET ASSEMBLY          |
| 2    | 1            | D4434-043   | FWD INBOARD BRACKET ASSEMBLY  |
| 3    | 1            | D4434-045   | FWD OUTBOARD BRACKET ASSEMBLY |
| 4    | 4            | AN525-832R7 | SCREW                         |



**D4434-041 FWD BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.38 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

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2014-03-31

|            |                                                                                                                                        |                                                                                                                                                                                                                                                                                           |               |
|------------|----------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| C          | ADD & CHANGE DIM TO 2 DEC PL (ZN C6-9, C7-9); REVISE D4434-045/-5/-6F (ZN B5-4, A5-10, B5-11); ADD ADHESIVE TO D4434-045 BOM (ZN D4-4) | RF                                                                                                                                                                                                                                                                                        | 14.03.06      |
| B          | RE-DESIGN D4434-9/-9F (ZN B5-14, A5-15)                                                                                                | RF                                                                                                                                                                                                                                                                                        | 12.02.22      |
| A          | NEW ISSUE                                                                                                                              | RF                                                                                                                                                                                                                                                                                        | 12.01.17      |
| REV.       | DESCRIPTION                                                                                                                            | BY                                                                                                                                                                                                                                                                                        | DATE          |
| DESIGN     | RF                                                                                                                                     | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                  |               |
| DRAWN      | RF                                                                                                                                     |                                                                                                                                                                                                                                                                                           |               |
| CHECKED    | DC                                                                                                                                     | DRAWING NO.                                                                                                                                                                                                                                                                               | REV. C        |
| MFG. APPR. | DD                                                                                                                                     | <b>D4434</b>                                                                                                                                                                                                                                                                              | SHEET 1 OF 15 |
| APPROVED   | HS                                                                                                                                     | TITLE                                                                                                                                                                                                                                                                                     | SCALE         |
| DE APPR.   | DS                                                                                                                                     | <b>COVER ASSEMBLY</b>                                                                                                                                                                                                                                                                     | NTS           |
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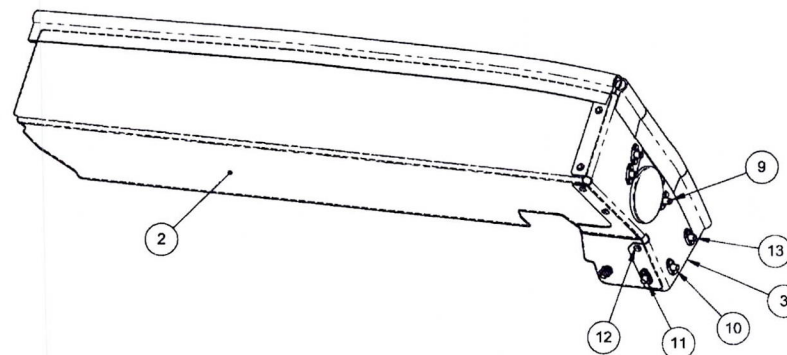
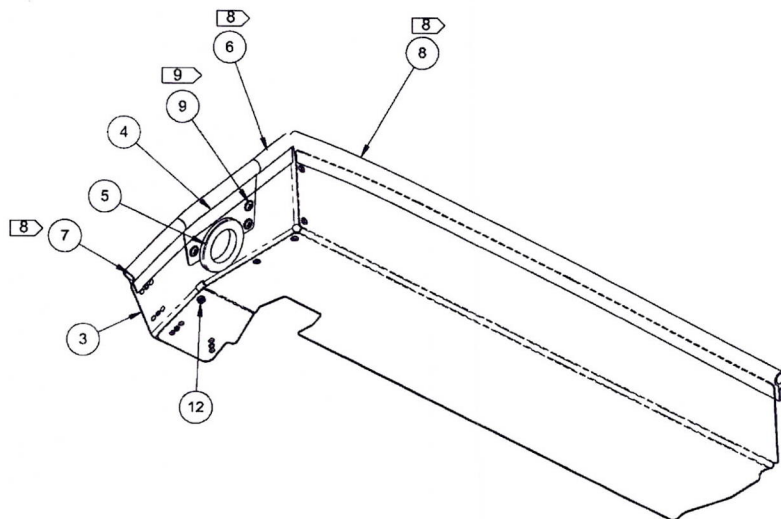
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| ITEM | QTY<br>-043 | PART NUMBER   | DESCRIPTION                  |
|------|-------------|---------------|------------------------------|
| 1    | X           | D4434-043     | FWD INBOARD BRACKET ASSEMBLY |
| 2    | 1           | D4434-1       | BRACKET                      |
| 3    | 1           | D4434-9       | BRACKET                      |
| 4    | 1           | D4435-041     | BRACKET ASSEMBLY             |
| 5    | 1           | D4440-1       | GROMMET                      |
| 6    | 1           | D4441-1-017   | RUBBER SEAL                  |
| 7    | 1           | D4441-1-025   | RUBBER SEAL                  |
| 8    | 1           | D4441-1-225   | RUBBER SEAL                  |
| 9    | 3           | AN525-832R6   | SCREW                        |
| 10   | 12          | MS20426AD3-2  | RIVET                        |
| 11   | 2           | MS20426AD3-3  | RIVET                        |
| 12   | 5           | MS20470AD4-3  | RIVET                        |
| 13   | 7           | MS21075L08    | NUT PLATE                    |
| 14   | A/R         | 3M 1300/1300L | ADHESIVE                     |



# **D4434-043 FWD INBOARD BRACKET ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3  
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.00 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE  
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL  
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TORQUE SCREW TO 12-15 (in-lb)

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|            |          |                                                                                                                                                                                                                                                                              |               |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                     |               |
| DRAWN      | RF       |                                                                                                                                                                                                                                                                              |               |
| CHECKED    | DC       | DRAWING NO.                                                                                                                                                                                                                                                                  | REV. C        |
| MFG. APPR. | DD       | D4434                                                                                                                                                                                                                                                                        | SHEET 2 OF 15 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                        | SCALE         |
| DE APPR.   | DS       | <b>COVER ASSEMBLY</b>                                                                                                                                                                                                                                                        | NTS           |
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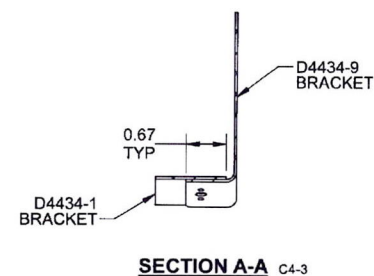
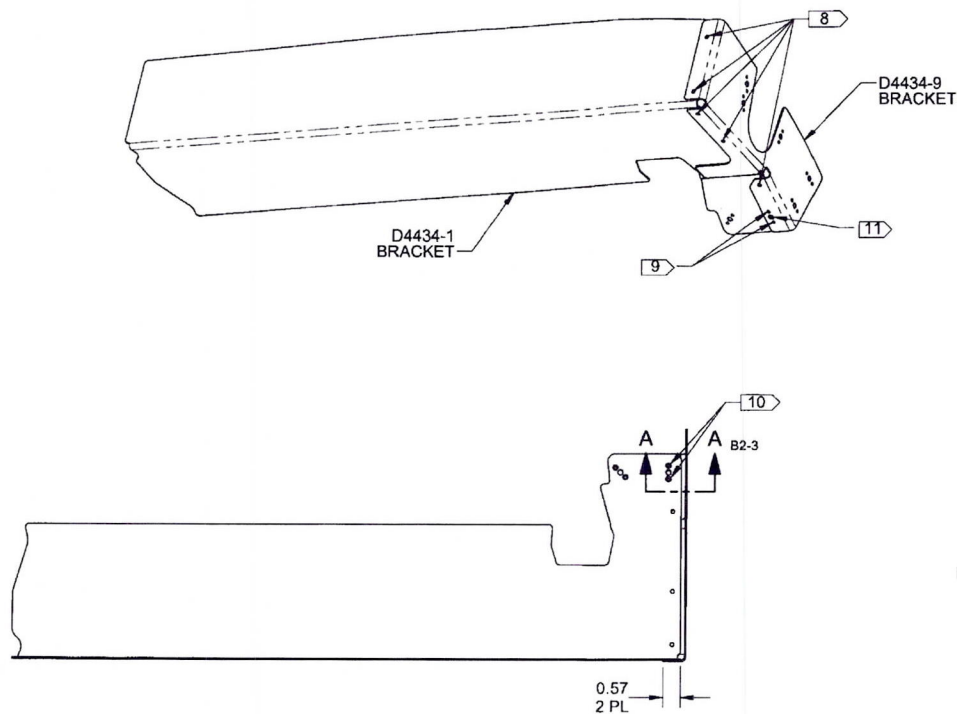
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# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.00 lbs
- 8) TRANSFER  $\phi 0.129$  HOLES THRU 5 PLACES FROM D4434-9 TO D4434-1
- 9) TRANSFER  $\phi 0.098$  HOLES THRU 2 PLACES FROM D4434-9 TO D4434-1
- 10) CSK  $\phi 0.179 \times 100^\circ$  ON THIS SIDE 2 PLACES
- 11) TRANSFER  $\phi 0.177$  HOLE THRU FROM D4434-9 TO D4434-1

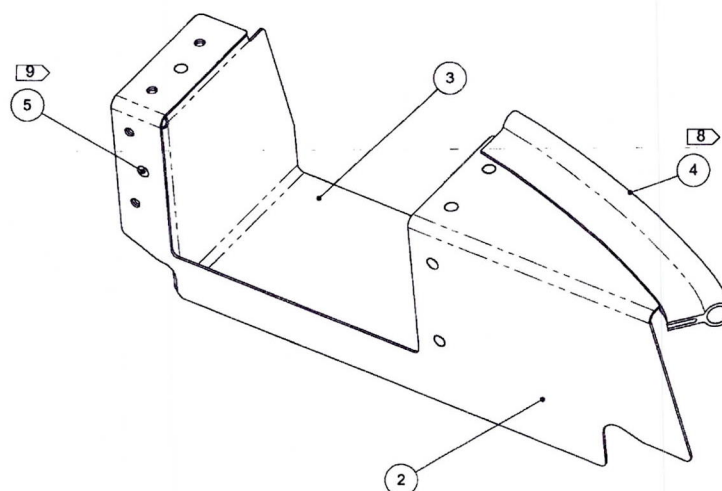
## **D4434-043 FWD INBOARD BRACKET ASSEMBLY** AUXILIARY VIEW

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2014-03-31

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|            |          |                                                                                                                                                                                                                                                                                           |               |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                  |               |
| DRAWN      | RF       |                                                                                                                                                                                                                                                                                           |               |
| CHECKED    | DC       | DRAWING NO.                                                                                                                                                                                                                                                                               | REV. C        |
| MFG. APPR. | DD       | <b>D4434</b>                                                                                                                                                                                                                                                                              | SHEET 3 OF 15 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                                     | SCALE         |
| DE APPR.   | DS       | <b>COVER ASSEMBLY</b>                                                                                                                                                                                                                                                                     | NTS           |
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| ITEM | QTY<br>-045 | PART NUMBER   | DESCRIPTION                   |
|------|-------------|---------------|-------------------------------|
| 1    | X           | D4434-045     | FWD OUTBOARD BRACKET ASSEMBLY |
| 2    | 1           | D4434-3       | BRACKET                       |
| 3    | 1           | D4434-5       | BRACKET                       |
| 4    | 1           | D4441-1-060   | RUBBER SEAL                   |
| 5    | 6           | MS20426AD4-4  | RIVET                         |
| 6    | A/R         | 3M 1300/1300L | ADHESIVE                      |



**D4434-045 FWD OUTBOARD BRACKET ASSEMBLY**

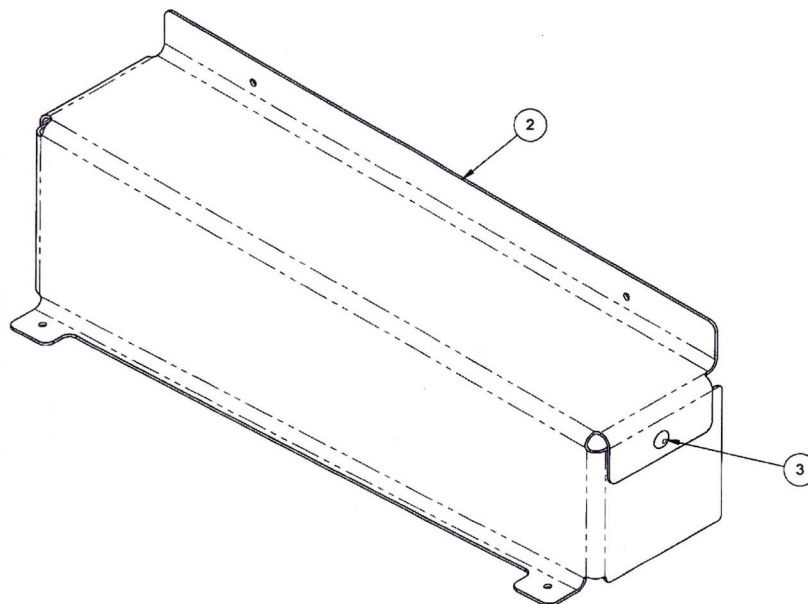
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3  
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.38 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE  
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL  
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TRANSFER  $\phi 0.129$  HOLE 6 PLACES AND CSK TO  $\phi 0.225 \times 100^\circ$

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2014-03-31

|          |            |          |                                                                                                                                                                                                                                                                                                  |               |
|----------|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| APPROVED | DESIGN     | RF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                         |               |
|          | DRAWN      | RF       |                                                                                                                                                                                                                                                                                                  |               |
|          | CHECKED    | DC       | DRAWING NO.                                                                                                                                                                                                                                                                                      | REV. C        |
|          | MFG. APPR. | DD       | D4434                                                                                                                                                                                                                                                                                            | SHEET 4 OF 15 |
|          | APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                                            | SCALE         |
|          | DE APPR.   | DS       | COVER ASSEMBLY                                                                                                                                                                                                                                                                                   | NTS           |
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| ITEM | QTY<br>-047 | PART NUMBER  | DESCRIPTION    |
|------|-------------|--------------|----------------|
| 1    | X           | D4434-047    | COVER ASSEMBLY |
| 2    | 1           | D4434-7      | BRACKET        |
| 3    | 2           | MS20470AD4-3 | RIVET          |



**D4434-047 COVER ASSEMBLY**

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2014-03-31

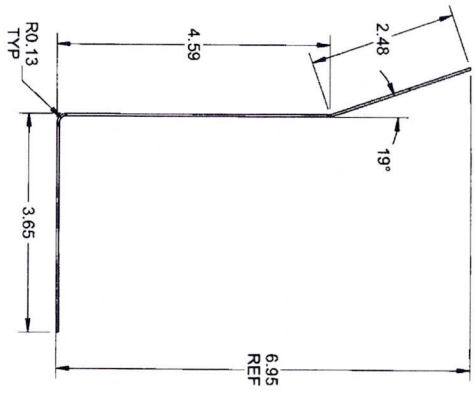
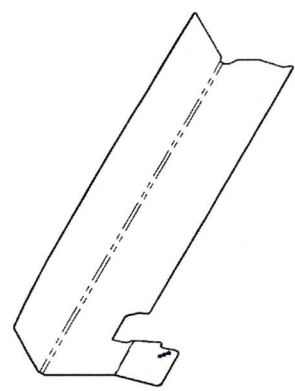
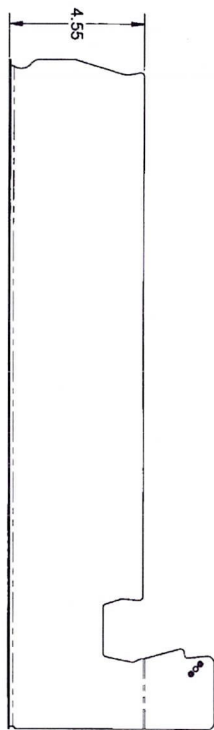
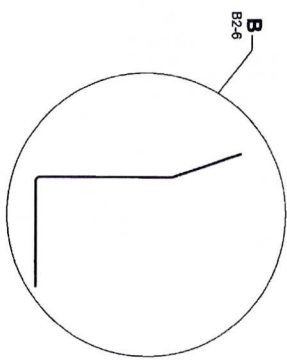
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.26 lbs

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|            |          |                                                                                                                                                                                                                                                                                                 |               |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                        |               |
| DRAWN      | RF       |                                                                                                                                                                                                                                                                                                 |               |
| CHECKED    | DC       | DRAWING NO.                                                                                                                                                                                                                                                                                     | REV. C        |
| MFG. APPR. | DD       | <b>D4434</b>                                                                                                                                                                                                                                                                                    | SHEET 5 OF 15 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                                           | SCALE         |
| DE APPR.   | DS       | <b>COVER ASSEMBLY</b>                                                                                                                                                                                                                                                                           | NTS           |
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# **D4434-1 BRACKET**

- NOTES:**
- 1) MATERIAL: MAKE FROM D4434-1F FLAT PATTERN
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
  - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

**APPROVED**

| DESIGN     | RF       | RF | DART AEROSPACE LTD          |
|------------|----------|----|-----------------------------|
| DRAWN      | RF       | RF | HAWKESBURY, ONTARIO, CANADA |
| CHECKED    | DC       | DC |                             |
| MFG. APPR. | DD       | DD | D4434                       |
| APPROVED   | HS       | HS | COVER ASSEMBLY              |
| DATE       | 14.03.06 | DS | SCALE NTS                   |

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2014-03-31

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SYSTEM WITHOUT PERMISSION FROM DART AEROSPACE LTD.



8 7 6 5 4 3 2 1

D

C

B

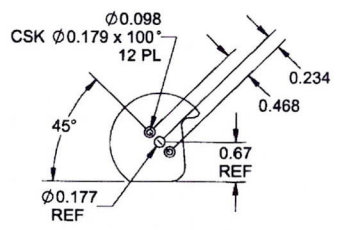
A

D

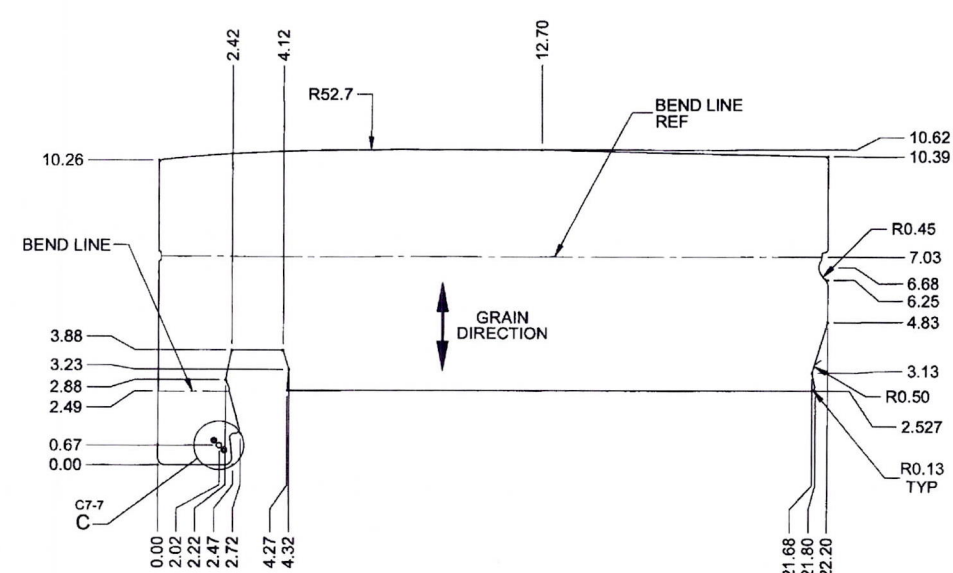
C

B

A



**DETAIL C**  
SCALE 2X  
B6-7



**D4434-1F FLAT PATTERN**

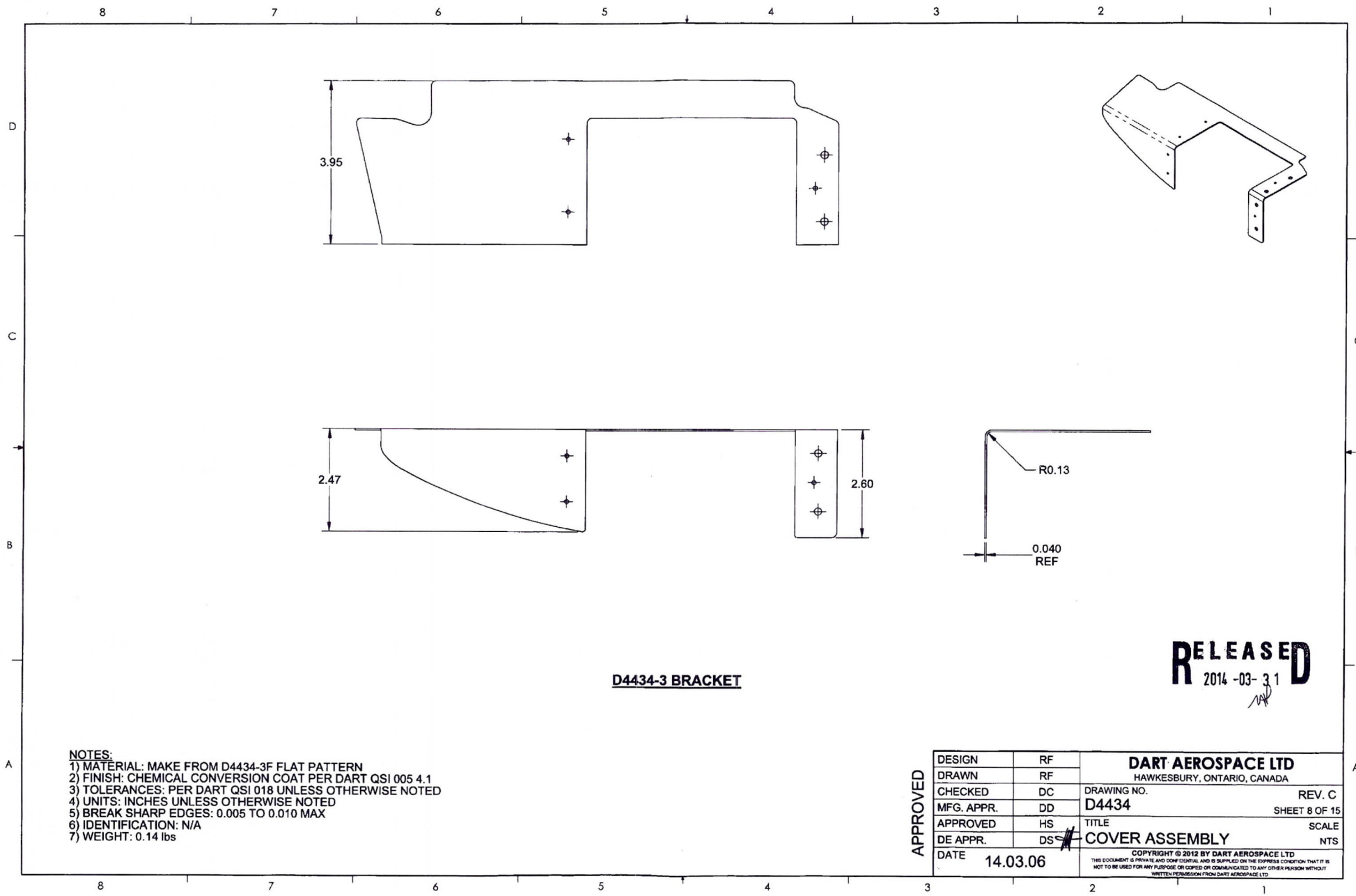
**RELEASED**  
2014-03-31

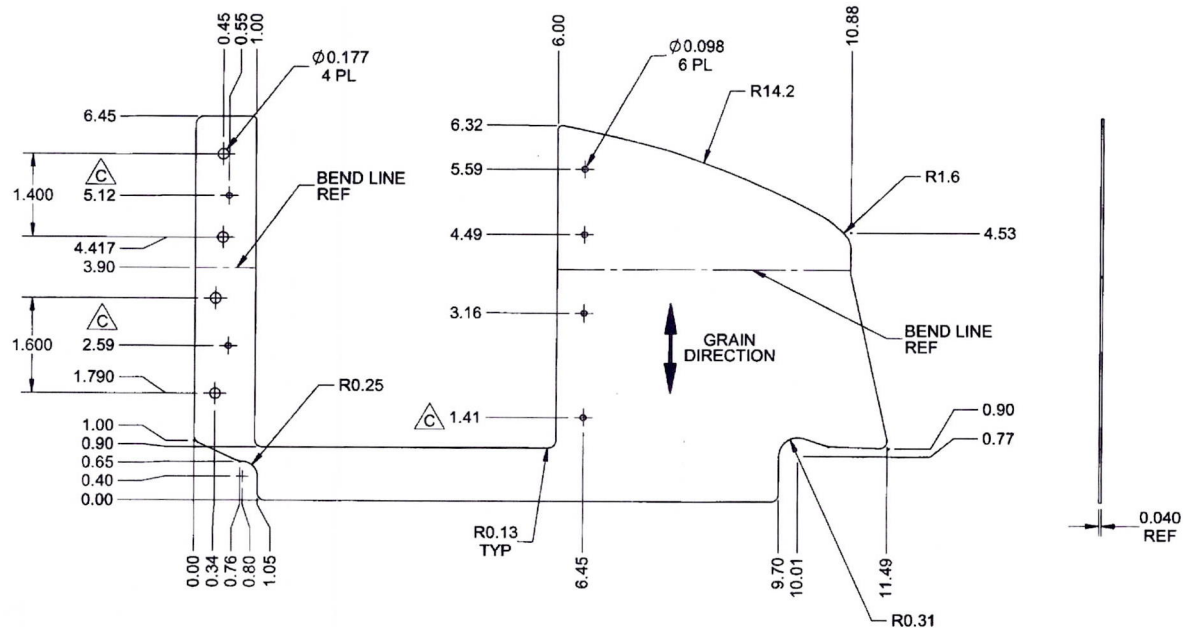
- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

APPROVED

|            |          |                                                                                                                                                                                                                                                                                |               |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                       |               |
| DRAWN      | RF       |                                                                                                                                                                                                                                                                                |               |
| CHECKED    | DC       | DRAWING NO.                                                                                                                                                                                                                                                                    | REV. C        |
| MFG. APPR. | DD       | <b>D4434</b>                                                                                                                                                                                                                                                                   | SHEET 7 OF 15 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                          | SCALE         |
| DE APPR.   | DS       | <b>COVER ASSEMBLY</b>                                                                                                                                                                                                                                                          | NTS           |
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8 7 6 5 4 3 2 1





**D4434-3F FLAT PATTERN**

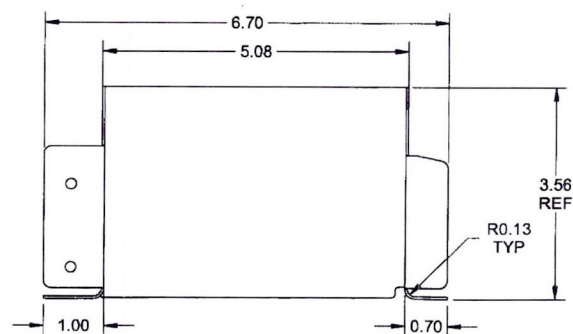
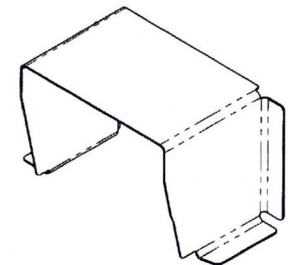
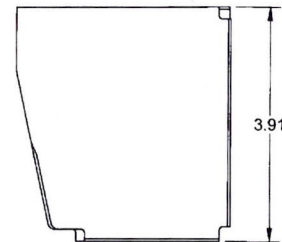
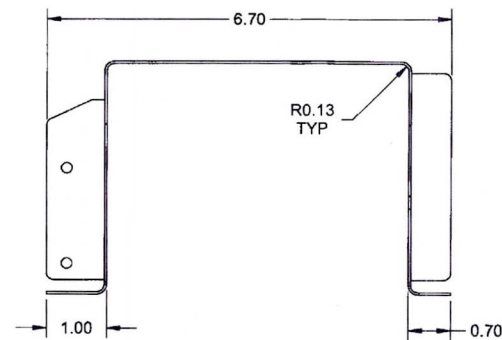
**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

APPROVED

|                                                                                                                                                                                                                                |                 |                             |               |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|-----------------------------|---------------|
| DESIGN                                                                                                                                                                                                                         | RF              | <b>DART AEROSPACE LTD</b>   |               |
| DRAWN                                                                                                                                                                                                                          | RF              | HAWKESBURY, ONTARIO, CANADA |               |
| CHECKED                                                                                                                                                                                                                        | DC              | DRAWING NO.                 | REV. C        |
| MFG. APPR.                                                                                                                                                                                                                     | DD              | <b>D4434</b>                | SHEET 9 OF 15 |
| APPROVED                                                                                                                                                                                                                       | HS              | TITLE                       | SCALE         |
| DE APPR.                                                                                                                                                                                                                       | DS              | <b>COVER ASSEMBLY</b>       | NTS           |
| DATE                                                                                                                                                                                                                           | <b>14.03.06</b> |                             |               |
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2014-03-31  
WNO



 **D4434-5 BRACKET**

**NOTES:**

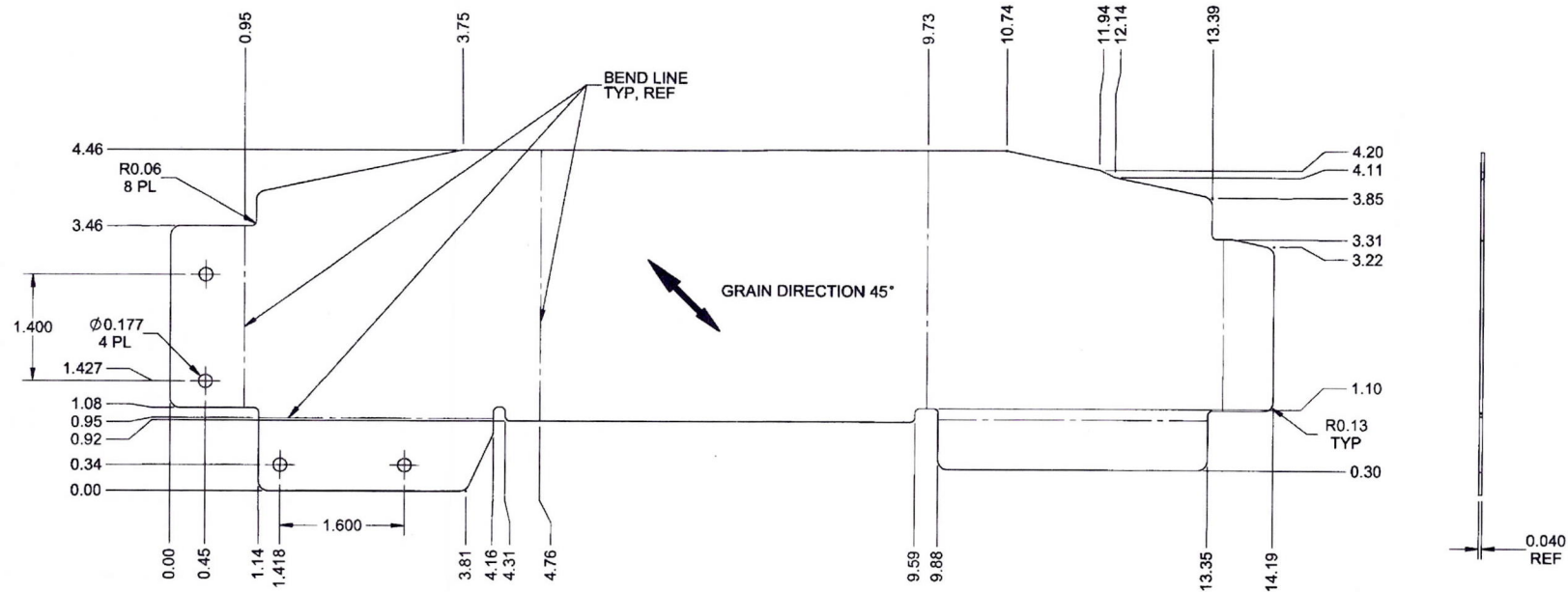
- 1) MATERIAL: MAKE FROM D4434-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs

APPROVED

|            |          |                                                                                                                                                                                                                                                                                          |                |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                 |                |
| DRAWN      | RF       |                                                                                                                                                                                                                                                                                          |                |
| CHECKED    | DC       | DRAWING NO.                                                                                                                                                                                                                                                                              | REV. C         |
| MFG. APPR. | DD       | <b>D4434</b>                                                                                                                                                                                                                                                                             | SHEET 10 OF 15 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                                    | SCALE          |
| DE APPR.   | DS       | <b>COVER ASSEMBLY</b>                                                                                                                                                                                                                                                                    | NTS            |
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2014-03-31





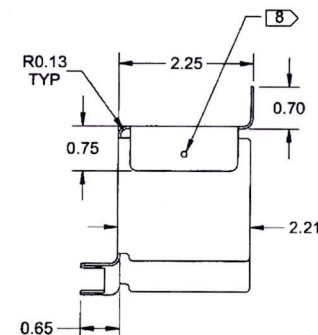
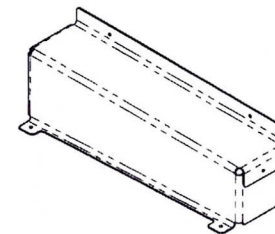
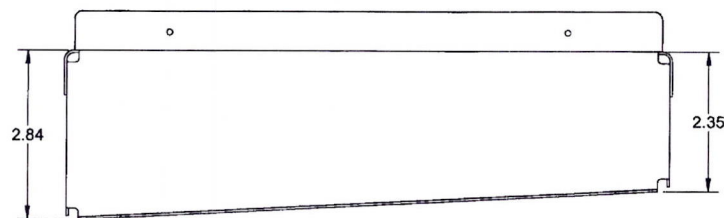
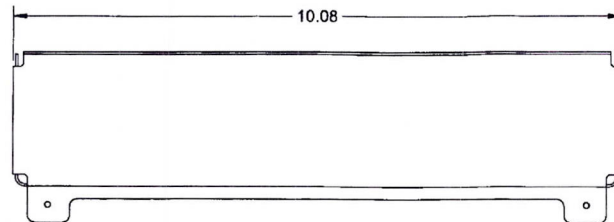
**D4434-5F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs

**RELEASED**  
2014-03-31

|          |            |          |                                                                                                                                                                                                                                                                                          |                |
|----------|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| APPROVED | DESIGN     | RF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                 |                |
|          | DRAWN      | RF       |                                                                                                                                                                                                                                                                                          |                |
|          | CHECKED    | DC       | DRAWING NO.                                                                                                                                                                                                                                                                              | REV. C         |
|          | MFG. APPR. | DD       | <b>D4434</b>                                                                                                                                                                                                                                                                             | SHEET 11 OF 15 |
|          | APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                                    | SCALE          |
|          | DE APPR.   | DS       | <b>COVER ASSEMBLY</b>                                                                                                                                                                                                                                                                    | NTS            |
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# **D4434-7 BRACKET**

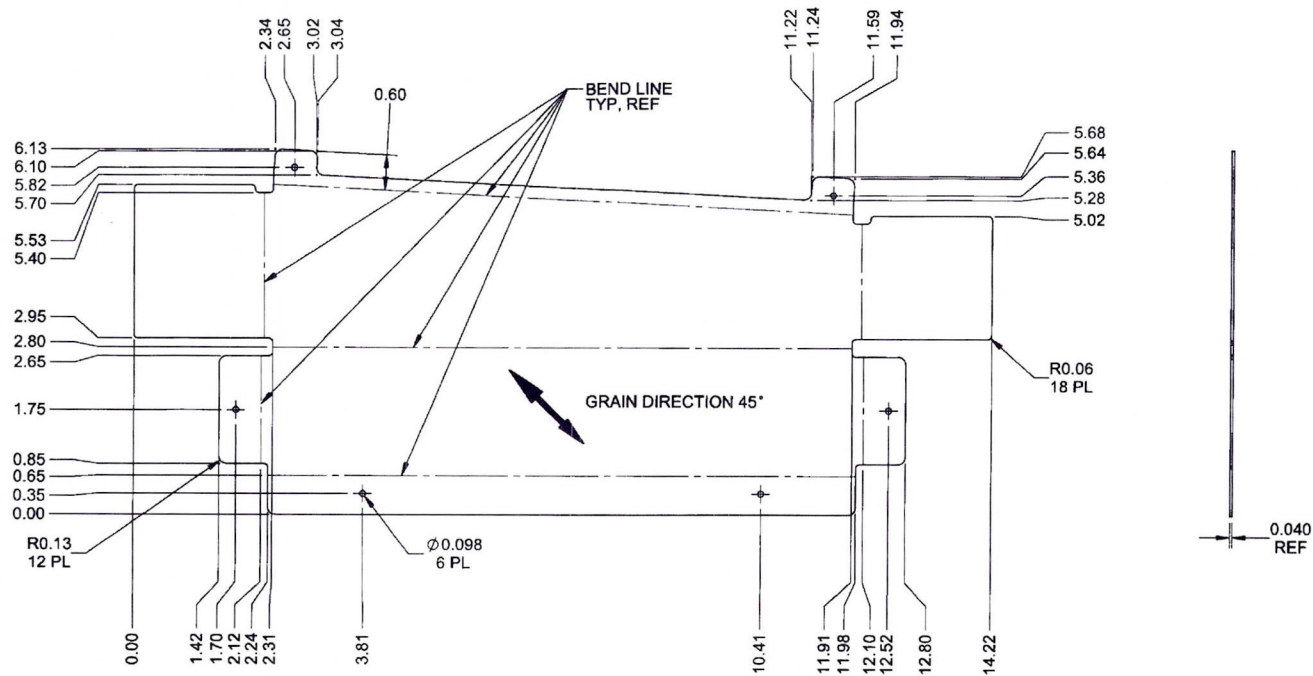
## **NOTES:**

- 1) MATERIAL: MAKE FROM D4434-7F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs
- 8) TRANSFER  $\phi 0.129$  HOLE THRU 2 PLACES

**RELEASED**  
2014-03-31

APPROVED

|            |          |                                                                                                                                                                                                                                                                                         |                |
|------------|----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                |                |
| DRAWN      | RF       |                                                                                                                                                                                                                                                                                         |                |
| CHECKED    | DC       | DRAWING NO.                                                                                                                                                                                                                                                                             | REV. C         |
| MFG. APPR. | DD       | <b>D4434</b>                                                                                                                                                                                                                                                                            | SHEET 12 OF 15 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                                   | SCALE          |
| DE APPR.   | DS       | <b>COVER ASSEMBLY</b>                                                                                                                                                                                                                                                                   | NTS            |
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**D4434-7F FLAT PATTERN**

**NOTES:**

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

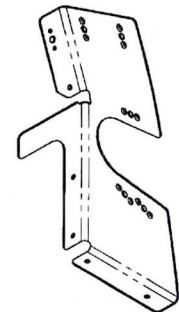
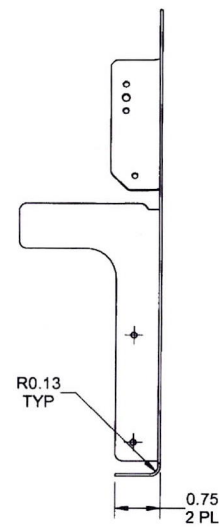
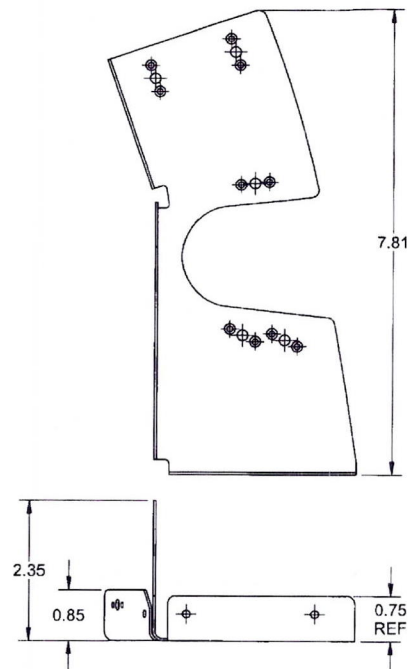
6) IDENTIFICATION: N/A

7) WEIGHT: 0.26 lbs

**RELEASED**  
2014-03-31

APPROVED

|            |          |                                                                                                                                                                                                                                                                                                  |                |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                         |                |
| DRAWN      | RF       |                                                                                                                                                                                                                                                                                                  |                |
| CHECKED    | DC       | DRAWING NO.                                                                                                                                                                                                                                                                                      | REV. C         |
| MFG. APPR. | DD       | <b>D4434</b>                                                                                                                                                                                                                                                                                     | SHEET 13 OF 15 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                                            | SCALE          |
| DE APPR.   | DS       | <b>COVER ASSEMBLY</b>                                                                                                                                                                                                                                                                            | NTS            |
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# **D4434-9 BRACKET**

## **NOTES:**

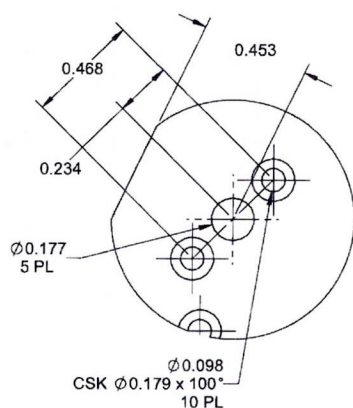
- 1) MATERIAL: MAKE FROM D4434-9F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

**RELEASED**  
2014-03-31

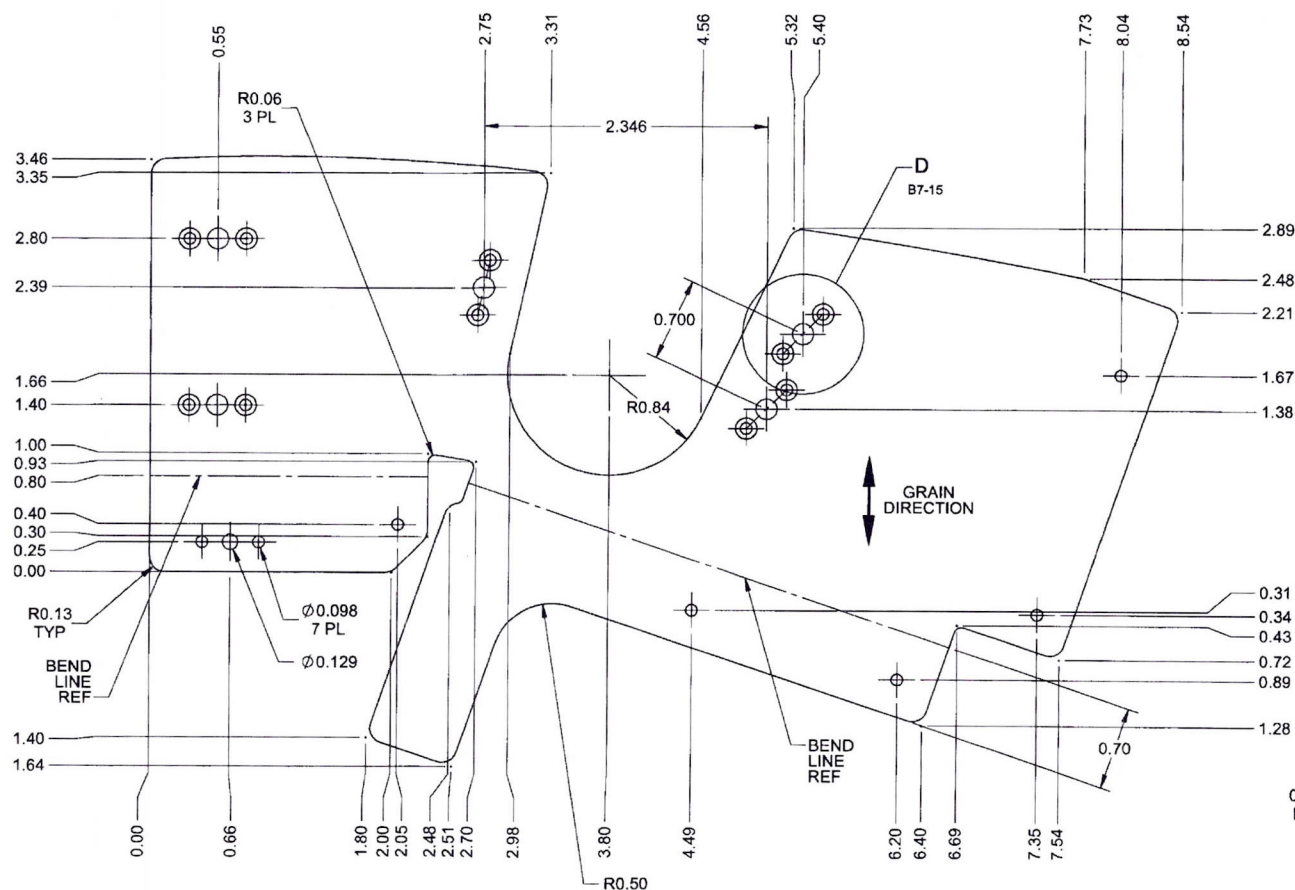
APPROVED

|            |          |                                                                                                                                                                                                                                                                            |                |
|------------|----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                   |                |
| DRAWN      | RF       |                                                                                                                                                                                                                                                                            |                |
| CHECKED    | DC       | DRAWING NO.                                                                                                                                                                                                                                                                | REV. C         |
| MFG. APPR. | DD       | <b>D4434</b>                                                                                                                                                                                                                                                               | SHEET 14 OF 15 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                      | SCALE          |
| DE APPR.   | DS       | <b>COVER ASSEMBLY</b>                                                                                                                                                                                                                                                      | NTS            |
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**DETAIL D**  
**SCALE 2X** C3-15



**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

**D4434-9F FLAT PATTERN**

**RELEASED**  
2014-03-31

APPROVED

|            |          |                                                                                                                                                                                                                                                                                |                |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                       |                |
| DRAWN      | RF       |                                                                                                                                                                                                                                                                                |                |
| CHECKED    | DC       | DRAWING NO.                                                                                                                                                                                                                                                                    | REV. C         |
| MFG. APPR. | DD       | <b>D4434</b>                                                                                                                                                                                                                                                                   | SHEET 15 OF 15 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                          | SCALE          |
| DE APPR.   | DS       | <b>COVER ASSEMBLY</b>                                                                                                                                                                                                                                                          | NTS            |
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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

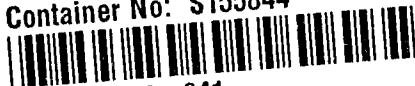
Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Sequence #: _____                                                                                                                 | QTY Affected : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |



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Container No: S155844



Part: D4434-041

Job No: 189578

Serial No/Batch: S155844

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/22/19